

NCR 19-7733



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D2345

Job Sheet 202281



Part No: D2345

Job Qty: 20 pcs

Part Name: Lock Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/19

Job Tracking No:

Due Date: 11/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPPRevB 99.05.31 Re-format DM IPP Rev:C Now on Waterjet 06-10-26 JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/18/19	0.17	1.45	Waterjet - Flow		DC 19/11/02
120	QC 8	20 pcs		11/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		NOV 04 2019 4:00
							QC 8 - 52		9:00
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - 2 - B4B	20 pcs		11/18/19	0.00	1.41	Small Fab - 1 - B4B		DAS 58 NOV 08 2019
							Small Fab - 2 - B4B		

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					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
140	Small Fab - Brake NC - B4B	20 pcs	11/18/19	0.25 1.33	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	DAS 58 NOV 08 2019
					Small Fab - Brake - 3 - B4B	
150	QC 5	20 pcs	11/18/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS 40 NOV 13 2019 9-89
					QC 5 - 61	
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	20 pcs	11/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	

				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	20 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-82 NOV 14 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg D2345 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Small Fab) Deburr if necessary. 140 - (Form as per dwg) Form as per Dwg D2345 using DT8241 Remove tooling tab and buff flush 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Identify as per dwg & Stock Location: _____) LOCATION : GA108 170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S18GA	304/316 .050 Sheet	1.0560 sf (.0528 ea)	100-Waterjet - Flow - 1	5214648	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S18GA	1	37	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Channel	2.800Inches ± 0.010	2.810 2.790		
2	Lock Channel	2.520Inches ± 0.010	2.530 2.510		
3	Lock Channel	0.094Inches + 0.004 - 0.001	0.098 0.093	Diameter	
4	Lock Channel	0.478Inches ± 0.010	0.488 0.468		
5	Lock Channel	1.256Inches + 0.005 - 0.001	1.261 1.255		
6	Lock Channel	0.197Inches ± 0.010	0.207 0.187	Diameter	
7	Lock Channel	2.750Inches ± 0.010	2.760 2.740		
8	Lock Channel	3.000Inches ± 0.010	3.010 2.990		
9	Lock Channel	0.050Inches ± 0.010	0.060 0.040		

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Entered: 28Date: Nov 19/19.NCR No. 14-7733

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>202281</u> Part No. <u>D2345</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																														
Date: <u>NOV 13 2019</u>		Sequence #: <u>150</u>		QTY Affected: <u>2 of 32</u>		MRB (QSI042)																												
Description Work Order Deviation				Disposition		DAS 9 9-89 <u>19-11-13</u>																												
<u>2 of 32 parts got damage during bending</u>				<u>- scrap</u>		Completed By DAS <u>NOV 13 2019</u> 40 9-89																												
						Lead hand / Supervisor DAS 9 9-89 <u>19-11-13</u>																												
						QC / QA Coordinator DAS 9 9-89 <u>19-11-13</u>																												
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☒ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☒ Off-set/Set-up</td> <td></td> </tr> </table>					☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☒ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☒ Off-set/Set-up	
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